

CLAIMS

1. A method for the bonding on surfaces after their painting wherein the surface to be bonded is a metal surface or a plastics surface, wherein the surface is coated with at least one structural polymer at least in the region of bonding, and wherein said surface is provided with at least one lacquer layer, and wherein said at least one lacquer layer is removed from the at least one structural polymer prior to the application of an assembly adhesive.

2. The method of claim 1, wherein the surface is a metal surface.

3. The method of claim 1, wherein the structural polymer is applied directly onto the surface.

4. The method of claim 3, wherein the surface is a metal surface that has not been treated by CDF-coating.

5. The method of claim 1, wherein after the application of the structural polymer an organic composition or in particular a cover tape is applied that is removed prior to the finishing.

6. The method of claim 1, wherein after the application of the structural polymer a cover tape is applied that is removed prior to the finishing.

7. The method of claim 1, wherein the structural polymer is a carcase work adhesive.

8. The method of claim 7, wherein the carcase work adhesive can absorb high strengths and has in particular a modulus of shear of  $> 5$  MPa, preferably  $> 8$  MPa.

9. The method of claim 1, wherein the removal of the lacquer layers is performed mechanically.

10. The method of claim 9, wherein the mechanically performed removal is made by grinding, planing, shaping, brushing or milling.

11. The method of claim 10, wherein the mechanically performed removal is made by milling.

12. The method of claim 1 wherein the assembly adhesive can absorb high strengths and in particular has a modulus of shear of  $> 5$  MPa, preferably  $> 8$  MPa.

13. The method of claim 1 wherein the assembly adhesive is used previously applied onto a construction part or module.

14. The method of claim 1 wherein the bonded part is a combination of construction elements and/or modules.

15. The method of claim 14, wherein said part produced is a part of a vehicle.